



Dart Aerospace Ltd.
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647.7335

Job Sheet 216153



Part No: 647.7335

Job Qty: 1 pcs

Part Name: EC135 T2/P2 Lower Cutter Removable Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/30/20

Job Tracking No:

Due Date: 12/18/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.7300 REV.G IPP REV:A 2020.04.01 NEW ISSUE DD VERF:RQ / IPP REV:B 2020.06.19 ASPER
DWG REV:F DD VERF:RQ /IPP REV C 20.09.24 AS PER DWG REV.G FK VERIFY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	12/18/20	12/18/20	0.00	0.00	Packaging 1 - SCH-S	84	DEC 09 2020
120					0.00	0.00	QC 4 - 28	9-89	
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
							QC 4 - 68		
							QC 4 - 72		
							QC 4 - 74		
							QC 4 - 75		
							QC 4 - 78		
							QC 4 - 84		
							QC 4 - 80		
							QC 4 - 85		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/18/20	12/18/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		



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Container No: S319323



Part: 647.7335

Job No: 216153

Serial No/Batch: S319323

DAS
72
9-89

DEC 09 2020

10/9/20

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				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	72
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	DEC 09 2020
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
135 DC - 1 - B4B	1 pcs	12/18/20	0.00 0.00	DC - 1 - B4B	DAS 21 9-89 DEC 09 2020
				DC - 2 - B4B	
140 QC 21 - FG	1 pcs	12/18/20	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 9	DAS
				QC 21 - FG - 77	21
				QC 21 - FG - 28	9-89

Part Op 110 - (Pick Kit)

Descriptions: 120 - (QC4- 100% Inspect kits for completeness)

130 - Identify and pack for shipping as per PPP 647.7335

135 - (Document Control) Photocopy bluefile & type labels per PPP 647.7335

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
601.3902	Eye Bolt	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
647.7501	Lower Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7702	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
93635A212	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	
AN3-11A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L3	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L5	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
NAS1149F0332P	Washer (AN960-10L)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	
NAS1149F0432P	Washer (AN960-416L)	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	
NAS1149F0532P	Washer (AN960-516L)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
NAS1149FN832P	Washer (AN960-8)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0990	1	26	0
	600.0991	1	26	0
	600.1012	1	13	0
	601.2045	1	22	0
	601.3902	2	36	0
	647.0112	2	10	0
	647.7501	1	5	0
	647.7702	2	8	0
	93635A212	4	9	0
	AN3-11A	2	146	0
	AN316C4R	2	46	0
	AN44-5A	2	13	0
	AN4C7A	2	56	0
	AN665-34R	2	28	0
	MS21042L08	2	1,870	0
	MS21042L3	2	1,464	0
	MS21042L4	2	1,215	0
	MS21042L5	2	310	0
	MS27039-08-13	2	186	0
	NAS1149F0332P	4	1,399	0
	NAS1149F0432P	8	1,041	0
	NAS1149F0532P	2	1,356	0
	NAS1149FN832P	4	2,133	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Fabrication

Job No: **216153**Part No: **647.7335**Sort by: ☐ Location ☒ Component

Operation	Required	Component	Description	BOM Quantity	Quantity Required	Quantity Available	Location	Container No	Serial No/Batch	Quantity Picked
110- Packaging 1 - Pick Kit	1	600.0990	Magnabond 6398 Part A Size 112 ml	1.0000	1.0000	1.0000	LG049	S314314	S314314	0
						17.0000	LG049	S314316	S314316	11-06-2021 1
						1.0000	LG050	S314692	S306325	0
						1.0000	LG049	S315117	S314314	0
						1.0000	LG050	S317173	S314314	0
110- Packaging 1 - Pick Kit	1	600.0991	Magnabond 6398 Part B Size 112 ml	1.0000	1.0000	2.0000	LG049	S314315	S314315	0
						17.0000	LG049	S314317	S314317	11-06-2021 1
						1.0000	LG050	S314693	S306327	0
						1.0000	LG050	S317174	S314315	0
110- Packaging 1 - Pick Kit	1	600.1012	Sealant PR1425B2 (#654 sem)	1.0000	1.0000	5.0000	CCK017	S312691	S312691	07-21-2021 1
110- Packaging 1 - Pick Kit	1	601.2045	RTV (LOCTITE 598)	1.0000	1.0000	3.0000	Small Fab - 1	S299615	S299615	0
						1.0000	CCK095C	S304317	S304317	1
						10.0000	CCK095C	S312295	S312295	0
110- Packaging 1	1	601.3902	Eye Bolt	2.0000	2.0000	1.0000	CCK100	S114848	S114848	08-20-22 0

						389.0000	ST263	S309801	S309801	4
						1,000.0000	ST260A	S318170	S318170	0
110- Packaging 1 - Pick Kit	1	NAS1149F0432P	Washer (AN960-416L)	8.0000	8.0000	160.0000	FP001	S247872	S247872	0
						6.0000	GA200	S247872-1	S247872	0
						729.0000	ST262	S316414	S316414	8
						12.0000	ST262	S317800	S309699	0
110- Packaging 1 - Pick Kit	1	NAS1149F0532P	Washer (AN960-516L)	2.0000	2.0000	600.0000	ST260A	FM133725	M133725	0
						740.0000	ST262	F18057-4	18057	2
						14.0000	GA200	f18057-4-1	18057	0
110- Packaging 1 - Pick Kit	1	NAS1149FN832P	Washer (AN960-8)	4.0000	4.0000	165.0000	FP001	S136368	S136368	0
						32.0000	ST260A	S293710	S293710	0
						576.0000	ST260A	S310426	S310426	0
						936.0000	ST263	S316423	S316423	4

Packaging 1 - Pick Kit										0
						2.0000	Crosstubes - 4 - B4B	S308481	S285188	0
						58.0000	ST303	S309678	S309678	2
						800.0000	ST299F	S314382	S314382	0
						2.0000	ST303	S318589	S204283	0
110- Packaging 1 - Pick Kit	1	MS21042L4	Nut	2.0000	2.0000	11.0000	GA011	S228833	S228833	0
						66.0000	FP001	S278891	S278891	0
						728.0000	ST303	S282343	S282343	2
						4.0000	ST303	S317797	S282343	0
						48.0000	ST303	S318124	S318124	0
						8.0000	ST303	S318590	S157064	0
110- Packaging 1 - Pick Kit	1	MS21042L5	Nut	2.0000	2.0000	37.0000	FP001	S283904	S283904	0
						1.0000	ST303	S302482	S302482	0
						50.0000	ST299F	S307427	S307427	0
						100.0000	ST299F	S312901	S312901	0
						98.0000	ST303	S316411	S316411	2
						200.0000	ST299F	S318125	S318125	0
110- Packaging 1 - Pick Kit	1	MS27039-08-13	Screw	2.0000	2.0000	26.0000	ST278	S123937	S123937	0
						56.0000	ST278	S306830	S306830	2
						100.0000	ST278	S314058	S314058	0
110- Packaging 1 - Pick Kit	1	NAS1149F0332P	Washer (AN960-10L)	4.0000	4.0000	2.0000	GA200	S103666-1	S103666	0
						282.0000	FP001	S216387	S216387	0

- Pick Kit						15.0000	CCK100	S248574	S248574	2
						20.0000	CCK100	S310831	S310831	0
110-Packaging 1 - Pick Kit	1	647.0112	Strut Bracket	2.0000	2.0000	6.0000	CCK106	S303073	S303073	2
110-Packaging 1 - Pick Kit	1	647.7501	Lower Cutter Assembly	1.0000	1.0000	2.0000	CCK042	S262104	S262104	0
						1.0000	CCK042	S267991	S267991	1
						1.0000	CCK042	S287320	S287320	0
						1.0000	CCK042	S287339	S287339	0
110-Packaging 1 - Pick Kit	1	647.7702	Strut Assembly	2.0000	2.0000	8.0000	CCK076	S243383	S243383	2
110-Packaging 1 - Pick Kit	1	93635A212	Bolt	4.0000	4.0000	9.0000	ST588	S255285	S255285	0
						50.0000	ST588	S318566	S318566	4
110-Packaging 1 - Pick Kit	1	AN3-11A	Bolt	2.0000	2.0000	18.0000	ST349	S304745	S304745	2
						100.0000	ST338F	S310893	S310893	0
110-Packaging 1 - Pick Kit	1	AN316C4R	Nut, Jam	2.0000	2.0000	42.0000	ST331	S312624	S312624	2
110-Packaging 1 - Pick Kit	1	AN44-5A	Eyebolt	2.0000	2.0000	1.0000	ST339	S298153	S298153	0
						10.0000	ST339	S304855	S304855	2
110-Packaging 1 - Pick Kit	1	AN4C7A	Bolt	2.0000	2.0000	52.0000	ST345	S235182	S235182	2
110-Packaging 1 - Pick Kit	1	AN665-34R	Clevis	2.0000	2.0000	4.0000	ST330	S235821	S235821	2
						10.0000	ST330	S316428	S316428	0
110-Packaging 1 - Pick Kit	1	MS21042L08	Nut	2.0000	2.0000	1,666.0000	ST303	S307361	S307361	2
110-Pick Kit	1	MS21042L3	Nut	2.0000	2.0000	151.0000	FP001	S304836	S304836	